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D4634-141
Job Sheet 202522



Part No: D4634-141

Job Qty: 1 pcs

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4634 REV.H SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - 1	1 pcs	11/15/19		0.00	1.67	Small Fab - 1		DAS 53 5-89	NOV 07 2019
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
							Small Fab - 8			
120	QC 5	1 pcs	11/15/19		0.00	0.00	QC 5 - 10		DAS 40 9-89	NOV 19 2019
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			
130	Packaging 3-1 - Stock - B4B	1 pcs	11/15/19		0.00	0.00	Packaging 3 - 1 - B4B			
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	58
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 100 - Small Fab (Small Fab) Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch 220 1300
 Descriptions: Batch: 5214687 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 5159491 Expiry Date 03/27/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: m138861
 120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O
 130 - Packaging3 (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____
 140 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-03	Cherry Rivet	4 Ea (4 ea)	100-Small Fab - 1	5180315
D4634-1	Fwd, Center Ceiling Panel	1 pcs (1 ea)	100-Small Fab - 1	517967
D4636-5	Bracket	1 pcs (1 ea)	100-Small Fab - 1	516535
D4647-5	Doubler	1 pcs (1 ea)	100-Small Fab - 1	5128081
D4664-5	Spacer	6 pcs (6 ea)	100-Small Fab - 1	5229999
D4712-1	Bracket	1 pcs (1 ea)	100-Small Fab - 1	5226769
D4732-15	Label <u>5224410</u>	1 pcs (1 ea)	100-Small Fab - 1	510435
D4732-19	Label <u>5224495</u>	1 pcs (1 ea)	100-Small Fab - 1	5008003
D5021-1	Foam, Center Panel, Fwd	1 pcs (1 ea)	100-Small Fab - 1	5224249
MPNY-750S-9-C	Mounting Pad	7 pcs (7 ea)	100-Small Fab - 1	Am120123-1
MS20426AD4-6	Rivet	2 Ea (2 ea)	100-Small Fab - 1	5216272
MS21059L08	Nut	2 Ea (2 ea)	100-Small Fab - 1	5140390

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	CCR264SS-3-03	4	176	0
	D4634-1	1	1	0
	D4636-5	1	41	0
	D4647-5	1	13	0
	D4664-5	6	7	0
	D4712-1	1	13	0
	D4732-15	1	15	0
	D4732-19	1	22	0
	D5021-1	1	2	0
	MPNY-750S-9-C	7	104	0
	MS20426AD4-6	2	873	0
	MS21059L08	2	139	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS										
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)									
Description Work Order Deviation				Disposition											
												Completed By			
												Lead hand / Supervisor		QC / QA Coordinator	
Root Cause				FAULT CATEGORY											
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐				Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐			
				Bending ☐				Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐			
				Crushing ☐				BOM/Route ☐		Grain Direction ☐		Drawing ☐			
				Cracks ☐				Broken/Damage/Defect ☐		Weld ☐		Finish ☐			
				Crimp/Kink/Ripple/Wave/Twist ☐				Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐			
				Marks/Chatter ☐				Drill Holes ☐		Out of Sequence ☐		Misread ☐			
				Mislabeled ☐				Fit/Function ☐		Off-set/Set-up ☐					
				Other/Details: _____											